Dart Aerospace Ltd.

Date: Tuesday, 11/21/2006 1:14:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SKIDTUBE ASSEMBLY
Job Number	: 29599		
Estimate Number	: 10022		
P.O. Number	: N/A	**Part Number**	: D205634011
This Issue	: 11/21/2006 **S.O. No.** : N/A	**Drawing Number**	: N/A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: N/A
Previous Run	: 29598	**Material**	: N/A
Written By	:	**Due Date**	: 12/11/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: KJ 06 11 21		
Comment	: Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D205-634-011 CHG004	KJ 06.11.28 (1)
2.0	29599A	SKID TUBE ASSEMBLY
	Comment: Sub-Component SKID TUBE ASSEMBLY D205-634-041 B 29599A	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
4.0	K10003	D205-634-011 Saddle Kit
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty / Part Number / Description / Batch 1 / K10003 / Saddle Kit / B29615 1 / D205-634-041 / Skidtube Assembly(ref) / 29599A	7/01/08 (1)
5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	SB 07/01/09 (1)

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 07/01/10

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:10 PM
User: Kim Johnston

Process Sheet

Customer:	CU-DAR001 Dart Helicopters Services	**Drawing Name:**	SKIDTUBE ASSEMBLY
Job Number:	29599	**Part Number:**	D205634011

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-011
Location:

7.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.

Date: Tuesday, 11/21/2006 1:14:40 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SKID TUBE ASSEMBLY
Job Number	: 29599A		
Estimate Number	: 10023		
P.O. Number	: N/A	**Part Number**	: D205634041
This Issue	: 11/21/2006 **S.O. No.** : N/A	**Drawing Number**	: D2580 REV C
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: C
Previous Run	: 29598A	**Material**	: N/A
Written By	:	**Due Date**	: 12/11/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: 06 11 21		
Comment	: Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev. O 06.02.28 Added paperwork EC		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001 N/A

2.0	D25001190	Ext'n -'I' Beam Tube 4"

Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B25858 m/h 06/11/24 ①

3.0	D2596	205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	22722 JD 06/11/30

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage JD 06/11/29 ①

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends JD 06/11/29 ①

3-Acid etch and Alodine tube per QSI 005 4.1 m.a 06/11/24 ①

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid) JD 06/11/29 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 29599A **Part Number:** D205634041

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

5-Open holes to 0.500" as per Dwg D2580without cutting fluid Pm/JD 06/11/29 (1)

6-Countersink holes as per Dwg D2580without cutting fluid Pm/JD 06/11/29 (1)

7-Deburr and blow out all chips from inside of tube Pm/JD 06/11/29 (1)

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting
Pick:

Qty	Part Number	Description	Batch
A/R		Sikaflex-291	m 102660

Pm/JB 06/11/29 (1)

Sikaflex expire date: 07/02/01
Start Time: 3:10 Date: 06/11/29
Fin Time: 8:30AM Date: 6-12-4

5.0 BENDING BENDING MACHINE

Comment: BENDING MACHINE
1-Bend as per program D2580.C on CNC Bender and Folio FT009
2-Cut tubes as per Dwg. D2580
DP 6-12-4

6.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1
1-Deburr ends after cutting. Remove alodine from around holes
Pm/JD 6-12-04 (1)

7.0 QC5 INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP BE 06-12-05

8.0 D25763 Step (Machining Detail)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	023060 BE 06-12-05

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

QA: N/C Closed: _____ **Date:** __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:40 PM
User: - Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 29599A **Part Number:** D205634041

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
9.0	D2579	Crossbolt Spacer

Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	329489 BE 06-12-05

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required. BE 06-12-05

2-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod m101446 BE 06-12-05

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending JD/pm 06-11-12 (1)

4-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web.Deburr pm 06-11-12 (1)

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes pm 06-11-12 (1)

6-Drill pilot holes for aft cap using DT 8215Open holes to #6 Drill bit. Deburr pm 06-11-12 (1)

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr pm 06-11-12 (1)

8-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod m101446 BE 06-12-05

11.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 06/12/11 (1)

12.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 06/12/11 (1)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29599A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 a.m/ JL. 06/12/27 0

Seq. #:	Machine Or Operation:	Description :
14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION YL 06/12/28 X1

Seq. #:	Machine Or Operation:	Description :
15.0	D25771	Wearplate Fwd

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	29488

Seq. #:	Machine Or Operation:	Description :
16.0	D25773	Wearplate Aft

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	29326

Seq. #:	Machine Or Operation:	Description :
17.0	D25775	Wearplate, Centre

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	28639

Seq. #:	Machine Or Operation:	Description :
18.0	ALS71032130	Insert

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
44	~~AL87~~-1032-130 ALS4-1032-130	Inserts	102475

YL 06/12/28

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 29599A | **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD10L	Washer

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4 4	AN960JD10L	Washer	102217

Seq. #:	Machine Or Operation:	Description :
20.0	AN34A	Bolt

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	102832

Seq. #:	Machine Or Operation:	Description :
21.0	D25941	Plug

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
plug
Batch: 28014

Seq. #:	Machine Or Operation:	Description :
22.0	D25943	O-Ring

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
o-ring
Batch: 27168

Seq. #:	Machine Or Operation:	Description :
23.0	D2855	Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: 26351

Seq. #:	Machine Or Operation:	Description :
24.0	AN35A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: ~~102832~~ m 15 205

YL 06/12/28

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29599A

Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	AN960JD10L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: 102217

YL 06/12/28

26.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 102672
Sikaflex expire date: 02/07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

YL 06/12/28

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 102672
Sikaflex expire date: 02/07

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 MM/R Batch: 06/28/12
M102672 + M103004

27.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024 FC 070105 (1)

28.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-041
Location:___________
PPP Rev:_____________

N/A

29.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE (1) 07/01/10

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS

QA COPY ISSUED

RELEASED 98/09/17 DS

Rev	Date	Description
A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097

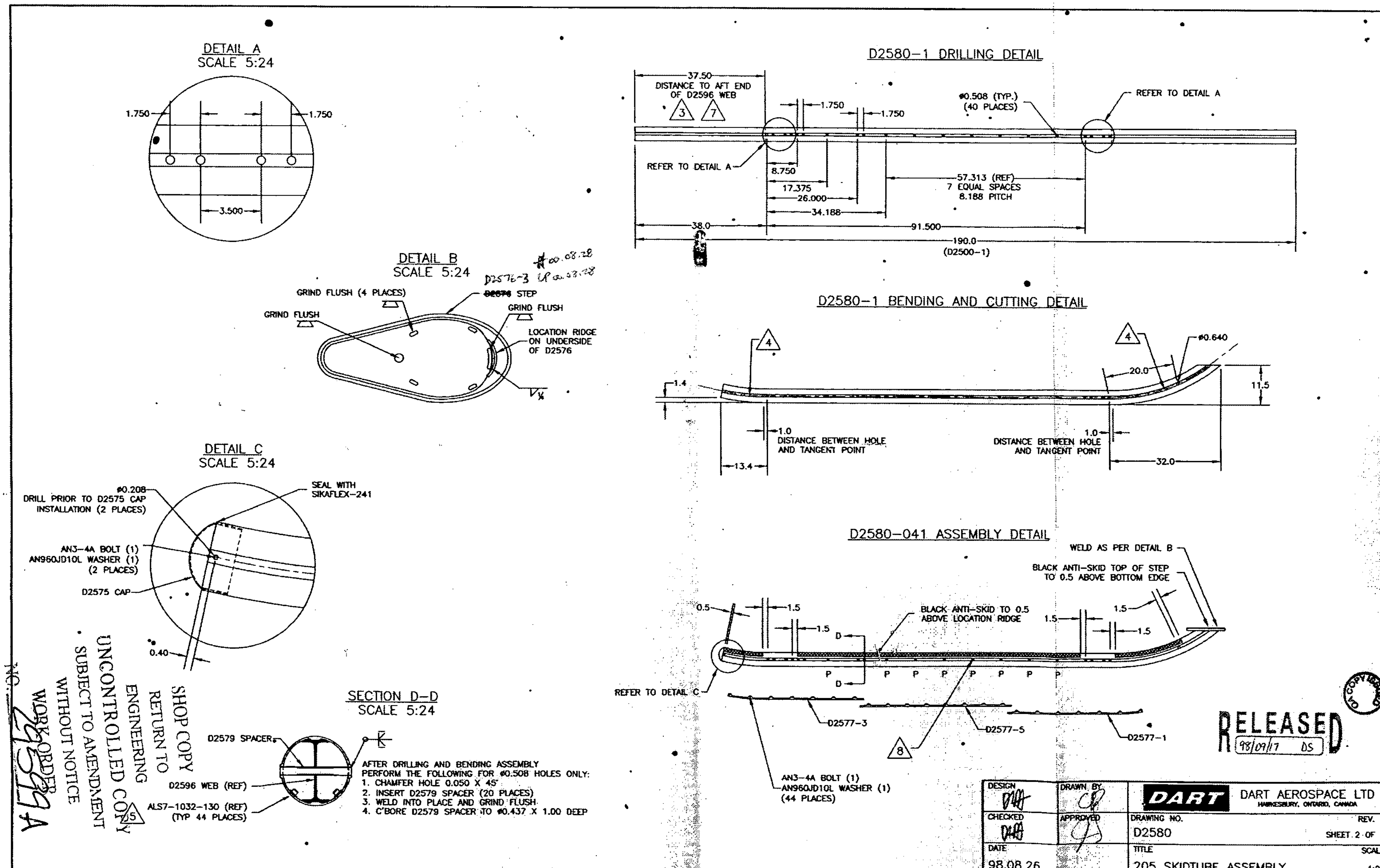
QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
00.08.28

EFFECTIVE	DEOs
98/12/14	DEO 9124
00.08.28	DEO 9183

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
   POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).


DETAIL A
SCALE 5:24
1.750
1.750
3.500
DETAIL B
SCALE 5:24
GRIND FLUSH (4 PLACES)
GRIND FLUSH
STEP
GRIND FLUSH
LOCATION RIDGE ON UNDERSIDE OF D2576
DETAIL C
SCALE 5:24
ø0.208
DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)
SEAL WITH SIKAFLEX-241
AN3-4A BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)
D2575 CAP
0.40
SECTION D-D
SCALE 5:24
D2579 SPACER
D2596 WEB (REF)
ALS7-1032-130 (REF)
(TYP 44 PLACES)
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2959A
D2580-1 DRILLING DETAIL
37.50
DISTANCE TO AFT END OF D2596 WEB
1.750
1.750
ø0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)
D2580-1 BENDING AND CUTTING DETAIL
1.4
ø0.640
20.0
11.5
1.0
DISTANCE BETWEEN HOLE AND TANGENT POINT
1.0
DISTANCE BETWEEN HOLE AND TANGENT POINT
13.4
32.0
D2580-041 ASSEMBLY DETAIL
WELD AS PER DETAIL B
BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE
BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE
0.5
1.5
1.5
1.5
1.5
1.5
REFER TO DETAIL C
D2577-3
D2577-5
D2577-1
AN3-4A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)
RELEASED
98/09/17 DS
QA COPY ISSUED
DESIGN
CHECKED
DATE 98.08.26
DRAWN BY
APPROVED
DART
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2580
REV. C
SHEET 2 OF 2
TITLE 205 SKIDTUBE ASSEMBLY
SCALE 1:24

NO. 80

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A205 634 041 / B29469 A

TEST WELDS REQUIRED

BASE METAL Alum **WELDING PROCESS** Tig
Penetration Complete [ ] Partial [✓] **Single Weld** [✓] **Double Weld** [ ]
Current AC [✓] DC [ ] **Backing** YES [ ] NO [✓]

	Position		**Vertical** Down [ ]	Up [ ]
Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

N/A

Crossbolt Spacer Welded into ____________ Skidtube

TEST RESULTS

Visual Pass [✓] Fail [ ]
Penetration Pass [✓] Fail [ ]

Crossbolt Spacer Pass [✓] Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/11/29 **Qualifier** [signature]

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